

Work Order ID 87891

87891

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July-17-12 2:50:39 PM

Item ID: D3836-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Rib Assembly (Basket Lid, RH)
 Start Date: 7/17/12 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 7/17/12 Req'd Qty: 2.00 ***2*** Customer:
 Reference: ECN12-603 REWORK

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3836	Rev A

100	Large Fab	0.00							
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1100
 Large Fab
 Large Fab
 Memo
 PULL FROM STOCK:
 2 X D3836-042 B77514
 REWORK PER DRWG D3836 REV.B
 PER ECN 12-60
 - drill hole and open to finish size as per dwg D3836 REV.B
 - weld ~~D3750~~ **D4021-9** bushing as per dwg D3836 REV. B
 12.07.16 A/R ER316 S.S. Rod Batch: **M121602**
 - grind weld flush where indicated on dwg

130	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
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130
 QC
 Quality Control

① PD 12-07-13
 ① 12.7.20 

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							<i>12.07.20</i>
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: <i>WA</i> Memo RE-IDENTIFY USING NEW B/N	0.00 0.00				<i>1X</i>		<i>12.7.23</i>	<i>12.07.23</i>
160 *160* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>12/7/23</i> <i>ME</i> <i>12-07-23</i>

Picklist Print

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Work Order ID: 87891

Parent Item: D3836-042

Parent Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 7/17/12

Required Date: 7/17/12

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:eC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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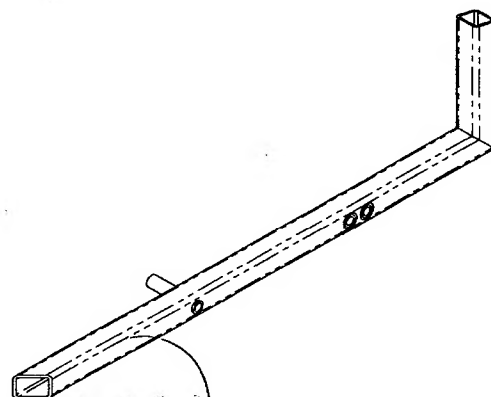
D3759-1 D4021-9 Bushing		Manufactured	No				Each	142.0000		2			
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Location	Loc Qty	Loc Code
WA	140	
79213	1	
83464	139	
WA005	2	
66489	1	
82785	1	

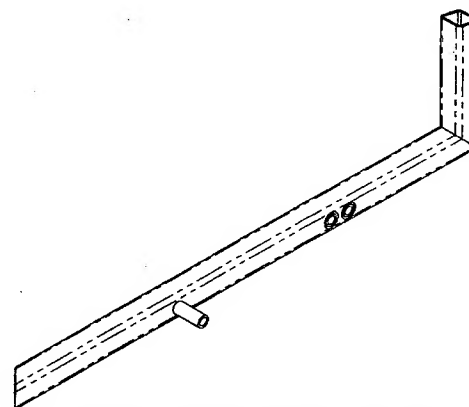
D3836-042 Rib Assembly (Basket Lid, RH)		Manufactured	No				Each	0.0000					
--	--	--------------	----	--	--	--	------	--------	--	--	--	--	--

B84717 → ② PD 12-07-13

B 77514 → ① CC 12-7-13



D3836-042 RIB ASSY (BASKET LID, RH)



D3836-041 RIB ASSY (BASKET LID, LH)

87891
(-7754)

NOTES:

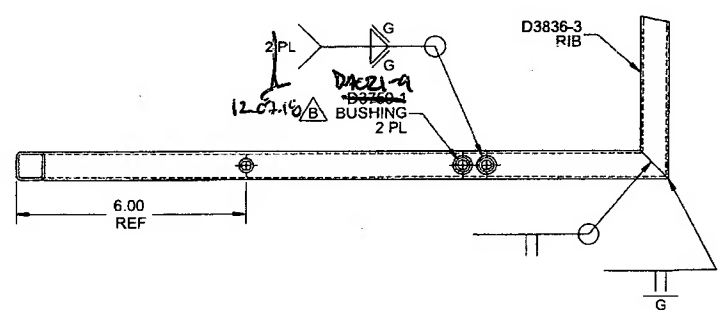
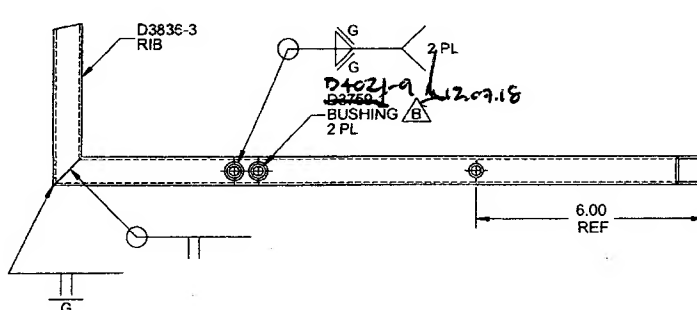
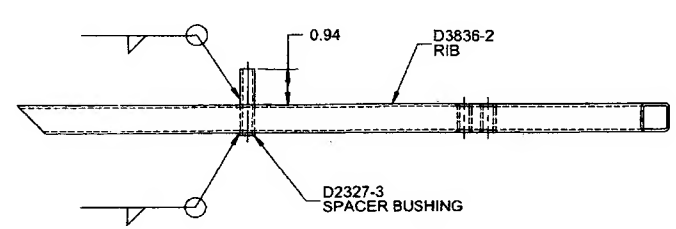
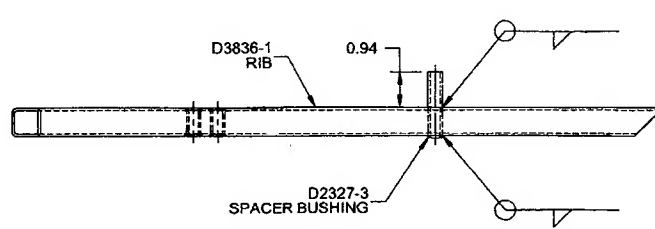
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.01 lbs EACH
- 8) WELD PER DART QSI 004

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3836-041	RIB ASSY (BASKET LID, LH)
2		X	D3836-042	RIB ASSY (BASKET LID, RH)
3	1	1	D2327-3	SPACER BUSHING
4	2	2	D3836-1	BUSHING D4021-9
5	1		D3836-1	RIB
6		1	D3836-2	RIB
7	1	1	D3836-3	RIB

RELEASED
2012-07-16
WMP

B	ADD QTY(2) D3759-1 BUSHING TO D3836-041/-042 (ZN D3-1, C6-2, C3-2, C6-3, C5-3, B6-3, B5-3) REASON: PAR10-50.	MB	12.05.11
A	NEW ISSUE	MB	08.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3836 TITLE RIB ASSY (BASKET LID) SCALE NTS COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESSED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.05.11		

8 7 6 5 4 3 2 1



D3836-041 RIB ASSY (BASKET LID, LH)

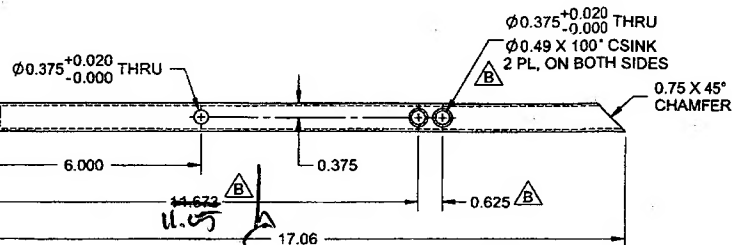
D3836-042 RIB ASSY (BASKET LID, RH)

RELEASED
2012-07-16

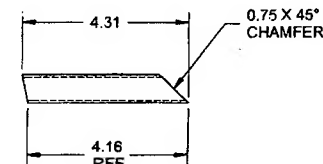
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3836	REV. B
MFG. APPR.		TITLE	SHEET 2 OF 3
APPROVED		RIB ASSY (BASKET LID)	SCALE
DE APPR.			NTS
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8 7 6 5 4 3 2 1

0.75 X 45°
CHAMFER

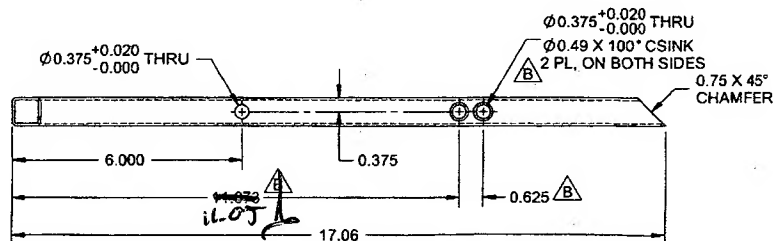


D3836-1 RIB

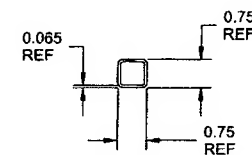


D3836-3 RIB

0.75 X 45°
CHAMFER



D3836-2 RIB



**TYPICAL SECTION
VIEW**

RELEASED
2012-07-16

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1/-2 = 0.77 lbs EACH; D3836-3 = 0.19 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3836	REV. B
MFG. APPR.		SHEET 3 OF 3	
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
DATE	12.05.11	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED BY THE EXPRESSED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

ENGINEERING CHANGE NOTICE

DART AEROSPACE LTD

Date: 12.07.11	Job No.: ENG3105	ADR Yes/No: Y	ADR Date: 12.05.11	ECN #: 12- 603
Product No.: D350-607-041/-043/-045/-047	Created By: [Signature]	Approved By: [Signature]		
Product Name: HELI-UTILITY-BASKET	Checked By: [Signature]			

Distribution	Reqd	Resp	Initial / Date
Production Manager / Coord.	Y	LL/MF	
Purchasing Coord.	N		
Production Engineering Coord.	Y	DD	
		EC	
		JLM	

Distribution	Reqd	Resp	Initial / Date
DQA / QA Coord.	Y	PS	
QC Coordinator	Y	ED	
Customer Technical Support	N		
Marketing	N		
Customer Order Processing	N		

Reason for Change:

CONTINUOUS IMPROVEMENT BASED ON PAR 10-50.

Documents Affected:

RELEASE D2512 REV. F, D3265, D3267 REV. D, D3266, REV. C, D3825, D3832, D3833, D3836 REV. B

PAPERWORK UPDATE ☐

PARTS MUST COMPLY ☒

PREVIOUS PARTS SATISFACTORY ☐

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	N			
5	Update Master Document List (MDL)	Y	MB	MDL-D350-607 REV. H	12.07.11
6	Update Product Compatibility Matrix	N			
7	Create Eurocopter Form (FEE)	N			
8	Notify TC / FAA of Change	N			
9					

#	Document Control Actions	Reqd	Resp	Notes	Complete
10	Move Electronic Files/Design Journal	Y	KJ		
11	Update Product Specification Files	N			
12	Update Approved/Preliminary Dwg PDF Files	Y	KJ		12.07.16
13	Update Document Record (DR)	N			
14	Update Product Development Summary	N			
15	Update QSI 021 and/or STC Approval List	N			
16	Create/Update Parts / STC Database	Y	KJ	SEE BELOW.	12.07.16
17	Update / Verify ARC Database	Y	KJ	SEE BELOW.	12.07.16
18	Create / Update Change Record Form / Item Card Database	Y	KJ	SEE BELOW.	
19	Create / Update PPP's	Y	KJ		
20	Red Decals required?	Y	KJ		
21	Update Document Control Database / Laminated Dwgs	N			
22	Update Grey Project / Electronic Binder PDF Files	Y	KJ	WITH ADR AND MDL	
23	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		
24					

Description / Action:

- ADD D3265-043/-7, D3825-043/-3, D3832-7/-9/-11/-13/-15, AND D3833-7 IN SYSTEM;
- REORGANIZE PARTS/BINS IN BASKET CELL;
- REVIEW ALL BOM'S AND W/O'S FOR D350-607-045/-047 BASKETS

NOTE ABOUT PARTS MUST COMPLY:

- D350-607-041/-043/-045/-047 IN STOCK/PROGRESS ARE ALL OK.
- D3825-041/-1 AND D3836-041/-042 IN STOCK WILL REQUIRE REWORK;

- D350-607-041/-041A NOW @ CHG 009/002 / D350-607-041 AGB @ CHG 002
- D350-607-043/-043A NOW @ CHG 006/002
- D350-607-045/-045A NOW @ CHG 004/002 / D350-607-045 AGB @ CHG 002
- D350-607-047/-047A NOW @ CHG 004/002

ECN Verified & Complete: _____

Date: _____